

Work Order ID 62200

Wednesday, September 22, 2010 10:23:08 A

Page 1

Item ID: D4148-041

Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/22/2010 Start Qty: 1.00

Required Date: 9/29/2010 Req'd Qty: 1.00

Reference:

PROTOTYPE

FOR TESTING ONLY
10.09.23

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *H*

Date: 10-9-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

SB 10/09/23

Q

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/09/23

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PARTS/ASSY TESTED
AND IN ENG. POSSESSION

10.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- Work Order ID 62200

Wednesday, September 22, 2010 10:23:08 A



Page 2

Item ID:	D4148-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Crosstube Lug Assembly, Fwd				Stop	
Start Date:	9/22/2010	Start Qty:	1.00			
Required Date:	9/29/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

RD 1356
NOV
RD 1356
NOV

MF
10-11-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries





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Page 1

[illegible]**Required Date:** 9/29/2010

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-5 		Manufactured	No			100	Each	6.0000	1	1			
Eyebolt Stud													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
					61005			6					
MS20615-4M18 		Purchased	No			100	Each	451.0000	8	8			
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST323				451					
					114808			152					
					115037			299					
D2690-6 		Manufactured	No			100	Each	31.0000	1	1			
Lanyard Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				31					
					59960			6					
					61382			25					
D4148-1 		Manufactured	No			100	Each	2.0000	2	2			
Crosstube Lug Plate, Fwd													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2					
					61006			2					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 10:23:17 AM

Page 2

Work Order ID: 62200

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 1.00

Required Qty: 1.00

D4148-3

Manufactured No

100

Each

6.0000

1

1



Stud Receiver, Lower

B 62202

Location

Loc Qty

Loc Code

GA

6

~~61007~~

6

D3910-1

Manufactured No

100

Each

9.0000

1

1



Crosstube Lug

① Sn 10/09/23

Location

Loc Qty

Loc Code

st507

9

59349

8

59708

1

D4091-1

Manufactured No

100

Each

5.0000

1

1



Mounting Lug

Sn 10/09/23

Location

Loc Qty

Loc Code

ST460

5

61008

5

AN3C12A

Purchased No

100

Each

72.0000

4

4



Bolts

Sn 10/09/23

1
4

Sn 10/09/23

Location

Loc Qty

Loc Code

ST351

72

112314

8

114761

11

115392

33

115594

20

4

Wednesday, September 22, 2010 10:23:17 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, September 22, 2010 10:23:17 AM

Page 3

Work Order ID: 62200

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN4C13A

Purchased

No

100

Each

91.0000

1

1



BOLT



SN 10/09/23

Location

Loc Qty

Loc Code

ST357

91

113359

3

114442

38

114615

50

MS17984-C413

Purchased

No

100

Each

18.0000

1

1



PIN, QUICK RELEASE



SN 10/09/23

Location

Loc Qty

Loc Code

ST297

4

114340

4

ST314

14

114523

1

114886

13

MS21043-3

Purchased

No

100

Each

2,615.000

4

4



Nut



SN 10/09/23

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2539

109147

4

111383

46

112314

2489

4

Wednesday, September 22, 2010 10:23:17 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, September 22, 2010 10:23:17 AM

Page 4

Work Order ID: 62200

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

817.0000

1

1



Nut



SN 12/09/23

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

777

112492

25

113069

8

114523

444

114784

300

NAS1149C0332R

Purchased

No

100

Each

1,187.000

8

8



Washer



SN 12/09/23

Location

Loc Qty

Loc Code

ST297

1187

113524

10

113737

150

115000

141

115698

886

NAS1149C0432R

Purchased

No

100

Each

682.0000

2

2



Washer



SN 10/09/23

Location

Loc Qty

Loc Code

ST297

682

114292

92

114742

590

2

Wednesday, September 22, 2010 10:23:17 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

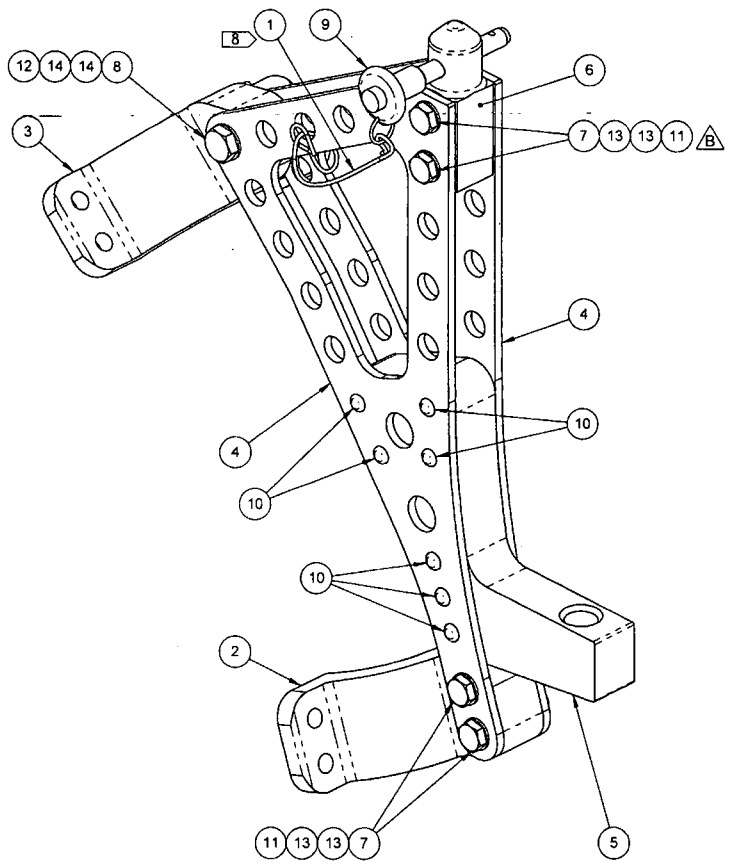
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	7	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62200
D/10-9-22

RELEASED
2010-07-16
md

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 3.47 lbs
 - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS Ø.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	10.07.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4148	REV. B
TITLE FWD X-TUBE LUG ASSY	SCALE NTS
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8 7 6 5 4 3 2 1

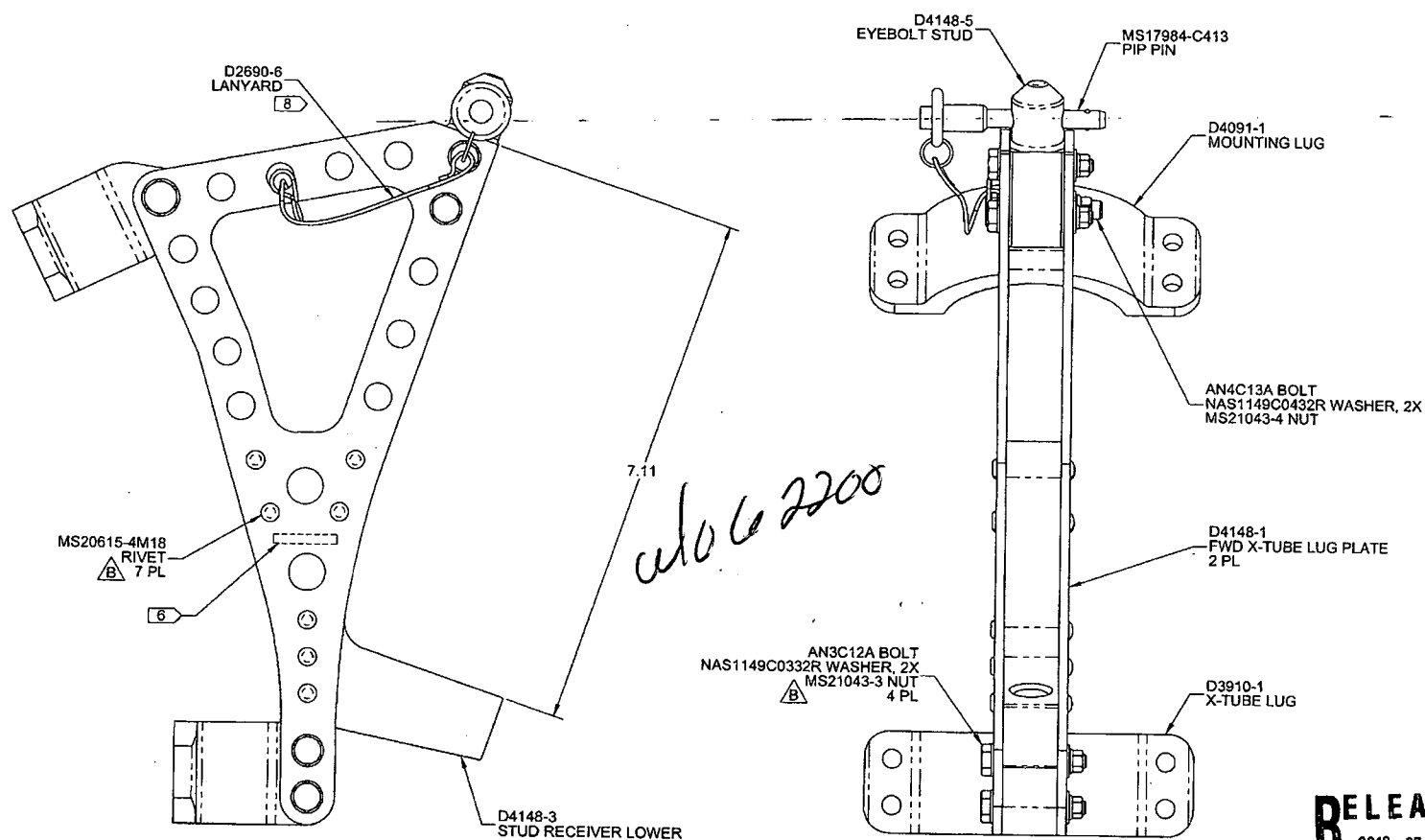
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

RELEASED
2010-07-16
mp

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4148	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	10.07.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

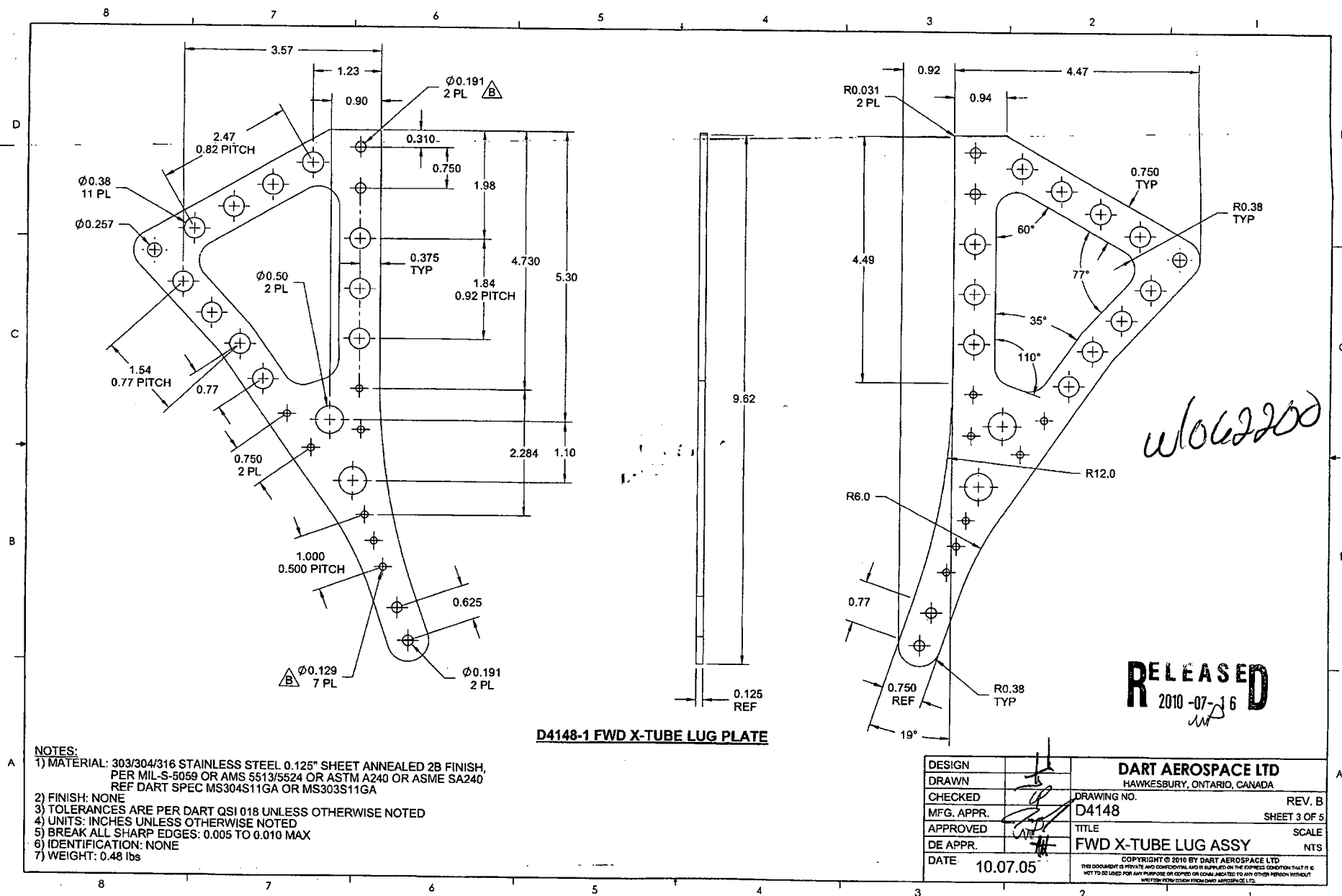
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

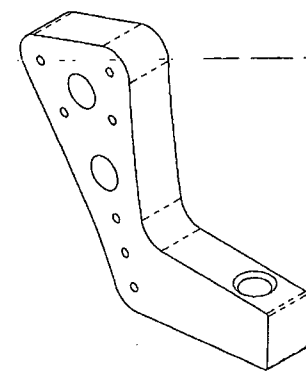
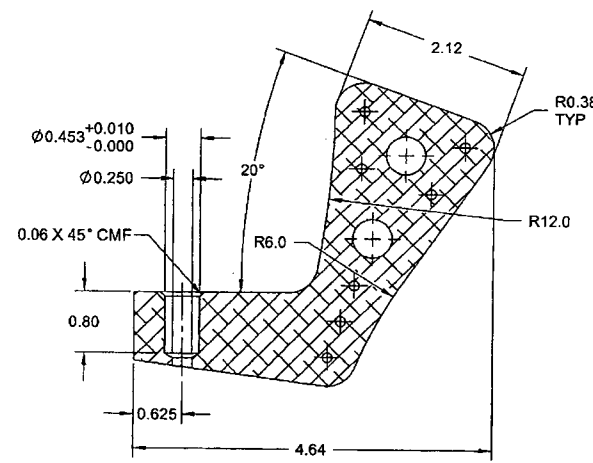
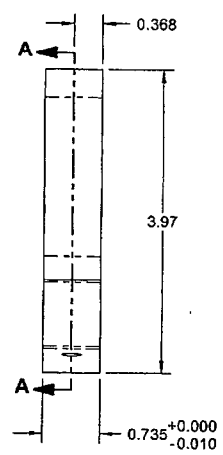
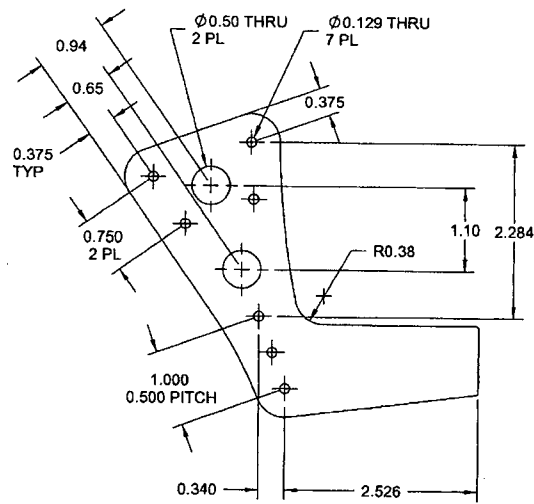
8 7 6 5 4 3 2 1

D

C

B

A



W662200

D4148-3 STUD RECEIVER LOWER

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.44 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4148	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.07.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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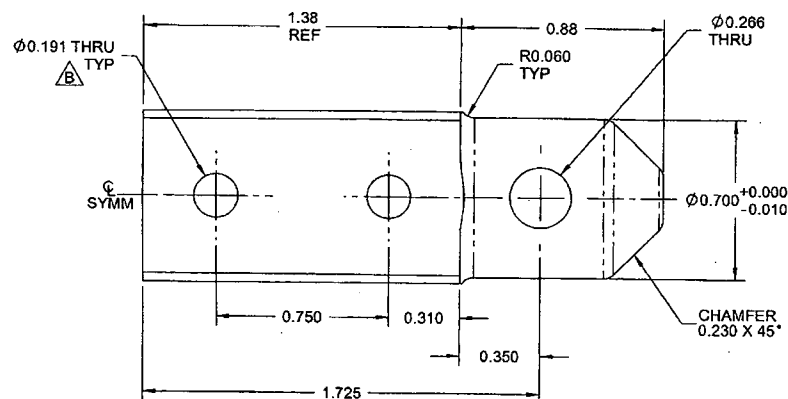
8 7 6 5 4 3 2 1

D

C

B

A



D4148-5 EYEBOLT STUD

w/o 62200

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4148
MFG. APPR.		REV. B
APPROVED		SHEET 5 OF 5
DE APPR.		TITLE FWD X-TUBE LUG ASSY
DATE	10.07.05	SCALE NTS
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8 7 6 5 4 3 2 1

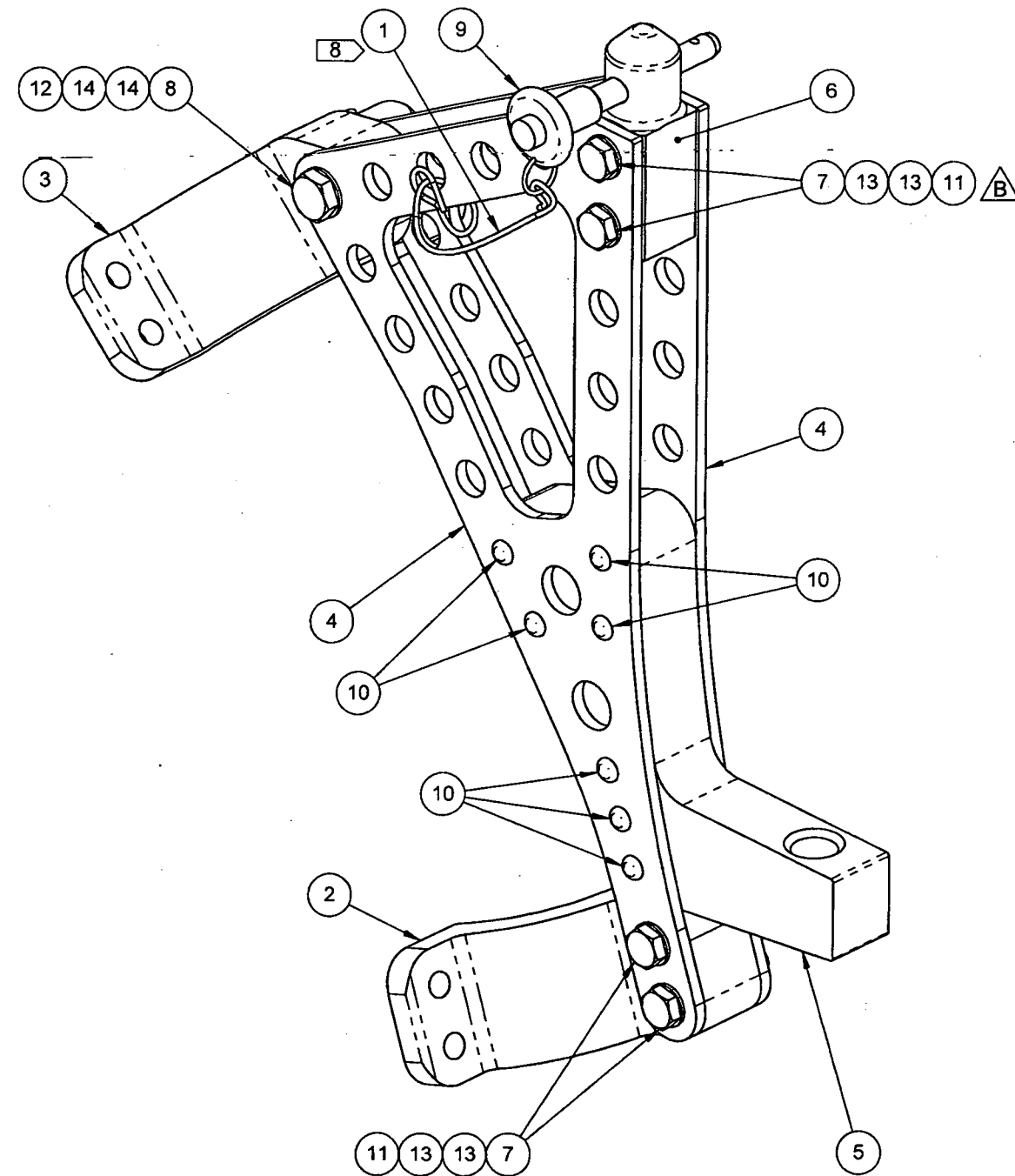
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D4148-041 FWD X-TUBE LUG ASSY

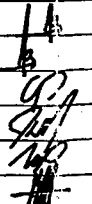
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 3.47 lbs
 - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	4	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

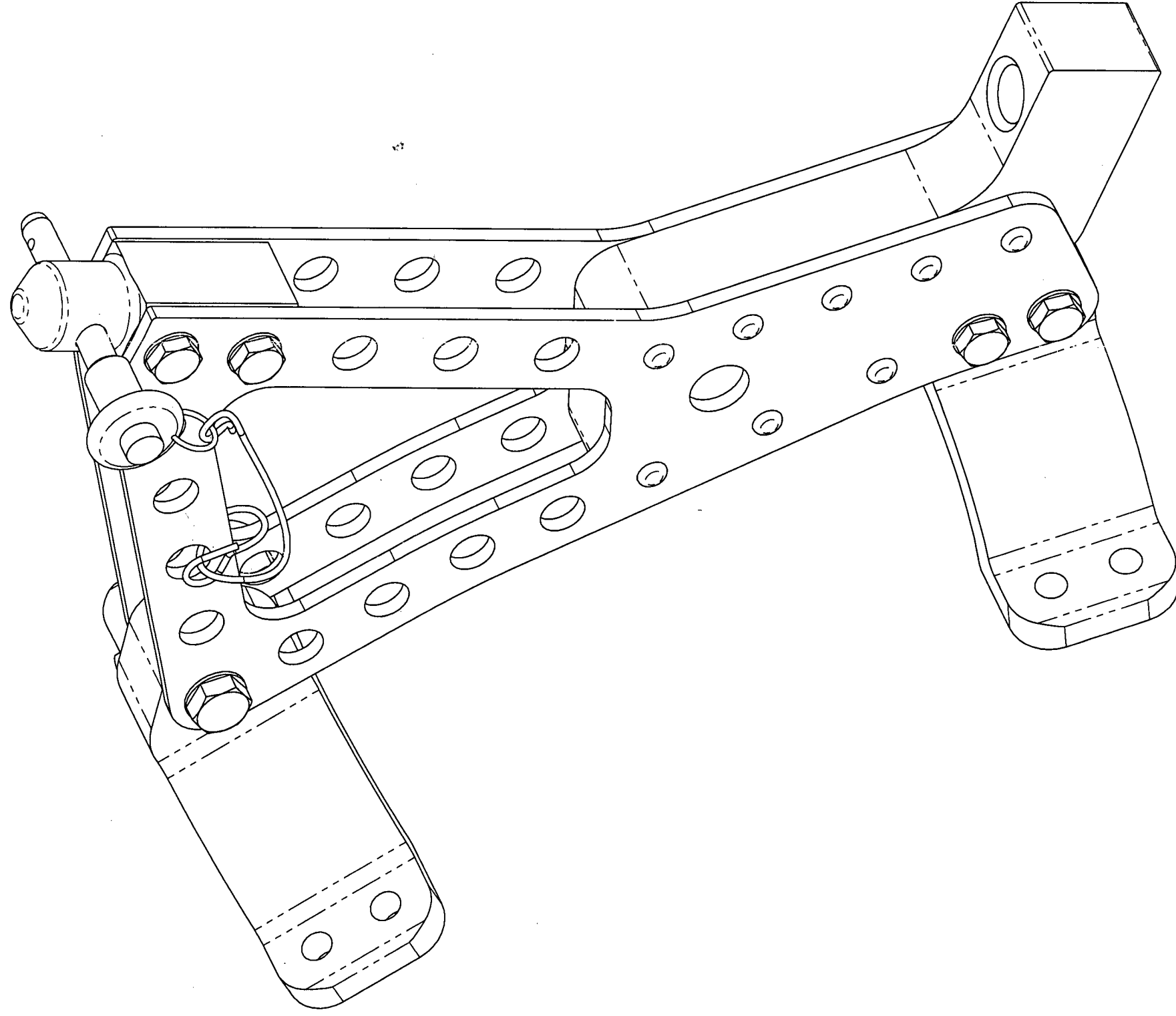
* SHAPE IS DIFFERENT
ASSY IS SIMILAR.
SEE SCREENSHOT ATTACHED.

REFERENCE ONLY
FOR MANUFACTURING
OF ONE PROTOTYPE
INCLUDE
MATERIALS
TO W/O

RELEASED
2010-07-16

B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS Ø.129 (ZN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
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